Work Order II May-13-13 1:03:32 P		<u>.</u>	*101	5 1	2*	· -=-	· <u>—</u> .	· _		<u>.</u>	· <u>—</u> ·	= Page	= : 1
Item ID: D306 Revision ID: Item Name: Step S	55-7 Spacer	· _ A	Accept	*N	190 <u>0</u>	<u>104</u> 0	1100)*	Setup S	tart top	*N *N	S1* S2*	= . *
Start Date: 5/13/ Required Date: 5/24/ Reference:		*100* *100*			Cust Item Customer				- 0				
Approvals: Proc	cess Plan: _ML5	Date: 13-05-/6	Tooling:)ate:				tart top	*N	R1*	
QC:	: - <u> </u>	Date:	SPC (Y/N):		1)ate:			,	μ	*N	R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	+	Tool ID	Tool #	Pian Code	Accept Qty	Reject Qty		Reject Number	Insp. Stamp	- · ←
Draw Nbr	Revision Nbr			- +-						-		•	_
D3065	Rev B			; - á —		- 						- _	
100 *100* Waterjot	FLOW WATER JET		0.00					100	<u>Q</u>		. <u> </u>	Ins	ÓF-1
FLOW CNC Waterjet		Owg D3065 Dwg Rev: cssary	B_Prog Rev:_B_	2-	1								1
110	QC2- Inspect parts off ma	chine FAI/FAIB	0.00									J.	
110 QC Quality Control	Memo		0.00					100	<u>_</u>		<u></u>	Im 13-0	7-11
120	QC8- Inspect parts - secon	nd check	0.00					1co			•		
120 QC Quality Control	Мето		0.00 37.	12	•			COL	2	_		. —	-

9

.

										DQA:	Date	:
NCR: Y	es / No				WORK ORDER NON-C	CON	FORM	MANCE / UPDATE		•		*
										QA Closed:	Date	•
Work Orde	r -				DISPOSITION			AGA	AINST DE	PARTMENT	PROCESS	
WOIR OIGE					Rework	7		Skid-tube Cros	stube		Water Jet	Engineering
Part N	0.				Scrap	1			ıll Fab	Proc	d. Eng. Coor.	Quality
					Use-as-is		Therm	noforming Fini	ishing	Rec/Stor	e/Packaging	Other
NCR N	0				Work Order Update]		Large Fab Comp	posite		Supplier	
Root		Ī		Descri	ption of work order update	In	nitial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Description	<u>. </u>	Date	Verification	QC Inspector
oc/Data												
quip/Taoling	_			l								
perator	_			:						;		
/laterial						ŀ						
etup	_		İ	!		ļ						1
)ther			1			i						
rocess	-	1										
upplier	\dashv											
raining	-		•							! 		
inapproved	1		1	l		AULI	CATE	GORY				
Landin	g Gear				General							
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre N	lot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
Ţ	Cracks				Broken/Damaged	\square	Inspecti	on Incomplete		Part Incorrec	it [Weld
	Crushed	/Crimped			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			1	Contamination		Mainte	nance		Part Moved		
	Heat Tre	eat			Countersink	\vdash	Mislabe			Positioned W	/rong	_
		on Strip in	Tube		Cut Too Short	Ш	Misread Offset	l		Power Loss/:	Surge	Other
	Ripples				Drill Holes	-						
1		Waves in I		n	Drawing	Ъ		Calibration				
	⊸ i	Sequence		L	Finish	\vdash		equence				
ŀ	Wave/T	wist in Tul	be	- 1	Folio	1 1	Outside	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

NCR.	Yes	1	No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____Date: _____

IVCK. TO	es / 140				WORK ORDER NON-		VIAITEL / OF	DAIL	QA Closed:	Date	<u> </u>
Work Orde	<u> </u>		•	<u></u>	DISPOSITION		-	AGAINST DE	PARTMENT,	/PROCESS	· ·
Part N					Rework Scrap	4 1	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	o				Use-as-is Work Order Update	Inern	noforming Large Fab	Finishing Composite	Rec/Stol	re/Packaging Supplier	Other
Root				Descri	iption of work order update	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data		1				ļ			 		
quip/Tooling	_	-									j
Operator											
Material	_			1							
etup	_									1	
Other											
rocess											
upplier	_										
raining	_									ļ	
Jnapproved					· · · · · · · · · · · · · · · · · · ·		<u></u>			<u> </u>	
		•		<u> </u>		AULT CATE	GORY				
Landin	g Gear			_	General			_	1	г	-
-	Bendin	-		. -	Bend	Grain		<u> </u>	Ovalized	. -	Pressure/Forced
-		Not Conce	ntric to	o/s _	BOM/Route	Hardwa		ļ	Over/Under	·	Temperature/Cure
Ļ	Cracks			-	Broken/Damaged		ion Incomplete		Part Incorred	 -	Weld
	—	d/Crimped			Burrs	-	tions Incomplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination	\vdash	enance		Part Moved		
1	Heat Tr			L	Countersink	Mislabe	•	<u> </u>	Positioned V		¬
,	—	ion Strip in	Tube	⊢	Cut Too Short	Misread	Ł		Power Loss/	Surge	Other
Ļ		in Bend		L	Drill Holes	Offset					· " - ·
Ļ	—	Waves in		n L	Drawing	⊢ −	Calibration				
1	 1	Sequence		<u> </u>	Finish		Sequence				
	Wave/	Twist in Tul	be	- 1	Folio	Outside	e Dimensions				

Work Order ID May-13-13 1:03:32 PM	101512	·	*101	512*				Page 3
tem 1D: D3065-7 Revision 1D: Item Name: Step Space Start Date: 5/13/13 Required Date: 5/24/13 Reference:		*100² *100²		*N900 Cust Item I Customer:		n* '	Setup Start Stop	*NS1* *NS2*
Approvals: Process QC:	s Plan:	Date:	Tooling: SPC (Y/N):		ate:	-	Run Start Stop	*NR1* *NR2*
Sequence ID/ Work Center ID 160 *160* HandFinish Hand Finishing	Operation Description Chemical Conversion Coa	at per QS1005 4.1	Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code	- •	Qty 3	Reject Insp. Number Stamp
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo		0.00	!		100	_ 	E\$13/0
180 *180* Packaging Packaging	ldentify as per dwg & Sto Memo	ock Location: GA	0.00			160	, . - 	

										DQA:	Date	•
NCR: Y	es / N	ס			WORK ORDER NON	-CO1	VFORI	MANCE / UPD	DATE			
										QA Closed:	Date	;
Work Orde	: г :				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N		····-			Rework Scrap Use-as-is	_ _ _	1	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	o				Work Order Update]		Large Fab	Composite]	Supplier	
Root	1			Desci	ription of work order update	┰	nitial	Acti	ion	Sign &		
Cause	Dat	Step	Qty		or Non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
occ/Data quip/Tooling Operator Material etup Other Process upplier Training												
Inapproved		i	<u></u>			FAIII	T CATE	GORY		<u> </u>	<u> </u>	. .
Landir	ng Gear				General	1701	. CALL	30111			<u>. </u>	
	Bendii Centro Cracks Crush Cuffs Heat Tinspec Ripple	e Not Conce ed/Crimped freat tion Strip in s in Bend e Waves in	n Tube Extrusion		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset Out of 0	ion Incomplete ions Incomplete/U enance eled d	Inclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Turnir	g Sequence	2	1	Finish		Out of S	Sequence				

Outside Dimensions

Wave/Twist in Tube

Folio

Work Ord May-13-13 1:0)1512		*101	1512*							Page 4	4
Item ID: Revision ID: Item Name: Start Date: Required Date Reference:	D3065-7 Step Spacer 5/13/13 :: 5/24/13	Start Qty: 100.00 Req'd Qty: 100.00		*100* *100*	*N90 Cust Ite		100)*	Setup	Start Stop		S1* S2*	
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		Date:			Run	Start Stop		R1* R2*	
Sequence ID/ Work Center 190 *1 QC* Quality Control	ID	Operation Description QC21- Final Inspection - V	Work Orde	Set Up/ Run Hours r Release 0.00	Tool I	D Tool#	Plan Code	Accept Qty	Qty	, I	Reject Number	Insp. Stamp	

M13-08-21

												DQA:	Da	te:	
NCR:	⁄es	/ No					WORK ORDER NON-C	100	NFORI	MANCE / UPDA	TE	QA Closed:	Da	te:	
Nork Orde	or.		,			Ţ	DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS		_
Part N	۱o.						Rework Scrap Use-as-is Work Order Update		Thern	Machining	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Quality
Root Cause		Date	Step	Qty	Desc	-	tion of work order update	1	nitial iief Eng	Action Descript		Sign & Date	Verificatio		QC Inspector
oc/Data quip/Tooling perator Material etup ther rocess upplier raining															
							F	AUL	T CATE	GORY			- "		
Landi	ng (Gear					General	AUL	.I CATE	GONT					
		Bending Centre No Cracks Crushed/G Cuffs Heat Trea Inspection Ripples in Torque W	Crimped at n Strip in a Bend Javes in E	Tube Extrusio			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset Out of 0	on Incomplete ions Incomplete/Unclenance eled i	lear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/	ct ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	l	Turning S	equence		- 1	1	Finish	1	Jout of S	Sequence					

Outside Dimensions

Wave/Twist in Tube

Folio

Picklist Print Page 1 May-13-13 1:03:32 PM Work Order ID: 101512 Start Date: 5/13/13 Required Date: 5/24/13 Parent Item: D3065-7 Start Qty: 100.00 Required Qty: 100.00 Step Spacer Parent Item Name: IPP: C02.11.01Incorporated D3066-1 IPPKJ/RF Comments: IPP Rev:D Now on Water Jet 06-04-11 JLM Component Item ID/ Qty per Kit Total Replacement Mfg/ Last Route Unit of Qty on Qty Date Status Bin Primary Item Name Location Measure Hand Issued -Issued Item ID Purch Seq ID Qty Item Location 100 sf 437.0877 0.1574 16.56842 M2024T3S.040 No Purchased JMB-07-11 2024-T3 .040 sheet Loc Code Location Loc Oty MAT022 437.0876922 65.8254832 120605 57.187894 121197

> 122136 123217

124987

31.78

261.4

124987

20,894315

										DQA:	Date:	
NCR: Ye	es / No				WORK ORDER NON-O	CON	IFOR1	VANCE / UPE	DATE	QA Closed:	Date:	, ,
Work Order	:	. ·			DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part No					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root	Date	Step	Qty	1	ption of work order update or Non-conformance		nitial ief Eng	Acti Descri		Sign & Date	Verification	QC Inspector
oc/Data quip/Tooling Operator Material etup Other rocess upplier Training												
Inapproved		<u> </u>	<u> </u>	<u> </u>	Ε	Δ111.	T CATE	GORY				
Landing	g Gear	·- <u>-</u> -			General							
	Cracks Crushed, Cuffs Heat Tre Inspection	at on Strip in n Bend Vaves in I	Tube Extrusio		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misread Offset Out of O	ion Incomplete tions Incomplete/U enance eled	Jnclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	st ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
}	Wave/Tv			-	Folio	\vdash		Dimensions				· ·

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	101512
Description: Step Spacer	Part Number:	D3065-7
Inspection Dwg: D3065 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article	Prototype
---	---------------	-----------

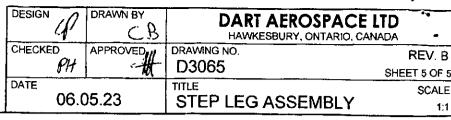
				_	7	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.000	0,130"	_		V	Jens:
0.865 (Pitch)	+/-0.005	C-867			v	
4.522	+/-0.010	4/525			.1	
0.250	+/-0.010	8.251"	,		~	
2.093	+/-0.010	2.095	-		v	
3.936	+/-0.005	3.934			V	
4.186	+/-0.010	4.190"	1		V	
Ø1.250	+/-0.005	1.252			R	
R0.125	+/-0.010	0.125	_		RG	
Grain Direction	N/A			_	1	
					-	
				-		
				-		
						·····
				-	-	
-	-					
						<u>-</u>

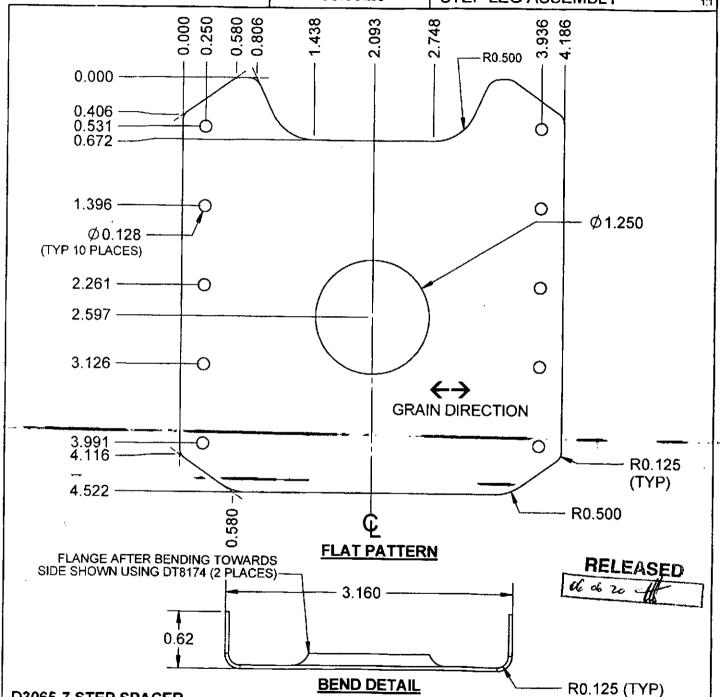
·····		<u> </u>		
Measured by: Jm	Audited by: 27		Prototype Approval: N/A	
Date: 3-07-11	Date:	B-7-R	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.05.15	Removed 0.531, 3.686, 0.580; Added 3.936 dimensions	KJ/JLM	
C .	06.06.23	Dwg Rev. changed	KJ/JLM A	911

,		بمر.	
		* - · <u>·</u> · ·	
•			
	ì.		







D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040) 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT © 2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

			•
			:
	,		
•		•	
* * ·			
(' ± ♥			. —